

5/35

DART AEROSPACE LTD

Work Order:

24048

Description: Spacer Block Kit

Part Number:

D206-667-011

Dwg: D3193 Rev. B, DSI 9263 Rev. A

Qty:

4 Kit(s)

BI

Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Note: D206-667-011 Kit consists of (2) D3193-041	HA	05.08.12	4																				
2	DC	Photocopy bluefile and create labels per PPP D206-667-011 CHG001 <i>UK 33 18</i> 6.000" (+0.030/-0.020)	DA	05.08.30	4																				
3	MV #14 04.03.18	Cut (2) blanks per (1) D206-667-011 Kit Cut blanks: 3.500" x 2.500" x 5.900" Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 Batch: <i>M18325</i>	PC	05.08.23	4																				
4	MV	Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1	SD	05.08.24	4																				
5	QC2	Inspect parts as they come off the CNC machine	SD	05.08.24	4																				
6	MV	Deburr and Tumble	JL	05.08.25	4																				
7	QC8	Second check	ML	05.08.25	4																				
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.08.27	4																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05.09.13	4																				
10	QC3	Inspect Powder Coat	ML	05.09.13	4																				
11	GA #14 04.03.23 #14 email 05.09.27	Assemble (2) D3193-041 as per Dwg D3193. (Note: D3193-1 is on BOM as material from Step 3). Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3193-1</td><td>Support Bracket</td><td>24048</td></tr><tr><td>16</td><td>MS20426AD3-5</td><td>Rivet</td><td>M17694</td></tr><tr><td>8</td><td>MS21073L4</td><td>Nut Plate</td><td>M14397</td></tr></table> Identify as D3193-041	Qty	Part Number	Description	Batch	2	D3193-1	Support Bracket	24048	16	MS20426AD3-5	Rivet	M17694	8	MS21073L4	Nut Plate	M14397	SB	05/11/29	4				
Qty	Part Number	Description	Batch																						
2	D3193-1	Support Bracket	24048																						
16	MS20426AD3-5	Rivet	M17694																						
8	MS21073L4	Nut Plate	M14397																						
12	QC5	Inspect work to Step 11	2	05.11.29	4																				
13	PK	Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3193-041</td><td>Spacer Block</td><td>1324048</td></tr><tr><td>8</td><td>AN4-6A</td><td>Bolt</td><td>SMC 16067 27 M18279</td></tr><tr><td>8</td><td>AN4-7A</td><td>Bolt</td><td>SMC 1831023 MEX 17697</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M18136</td></tr></table>	Qty	Part Number	Description	Batch	2	D3193-041	Spacer Block	1324048	8	AN4-6A	Bolt	SMC 16067 27 M18279	8	AN4-7A	Bolt	SMC 1831023 MEX 17697	16	AN960JD416	Washer	M18136	W	05/11/30	4
Qty	Part Number	Description	Batch																						
2	D3193-041	Spacer Block	1324048																						
8	AN4-6A	Bolt	SMC 16067 27 M18279																						
8	AN4-7A	Bolt	SMC 1831023 MEX 17697																						
16	AN960JD416	Washer	M18136																						
14	QC4	Inspect Kit 100% for completeness on the W/O	CL	05/11/30	4																				
15	PK	Identify and pack for shipping as per PPP D206-667-011	DEVB	05/11/30	4																				
16	AC	Cost / part																							
17	DC	Close W/O Inspect Level 21	19	05/12/01	4																				

Rev	Date	Change	Revised By	Approved
A	04.01.06	New issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

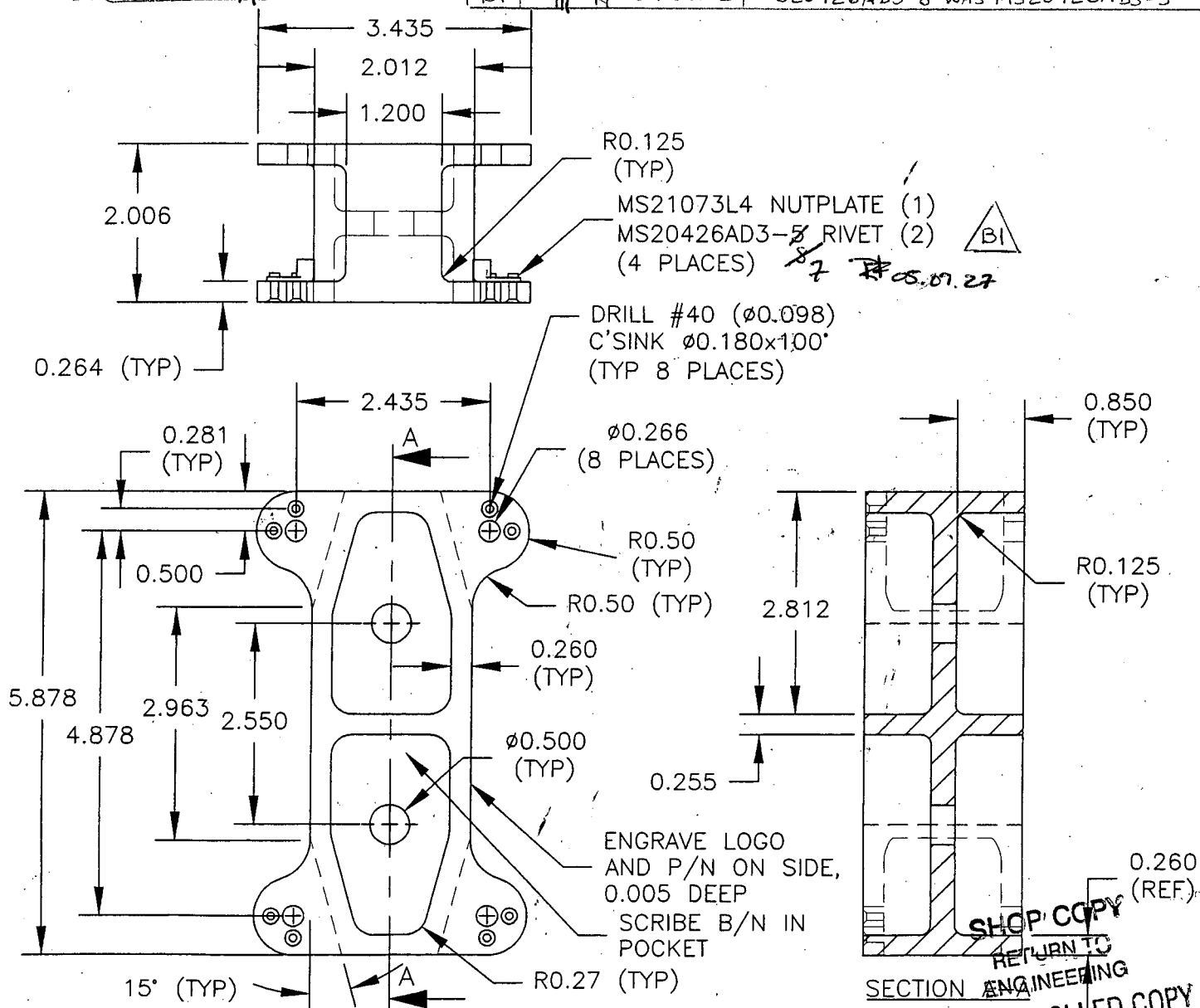
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 05/12/01

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3193	REV. B SHEET 1 OF 1
DATE 03.12.22		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
BI	04.03.22	MS20426AD3-8 WAS MS20426AD3-5	

RELEASED
04.01.12



D3193-041. SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK* ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER
NO. 24048

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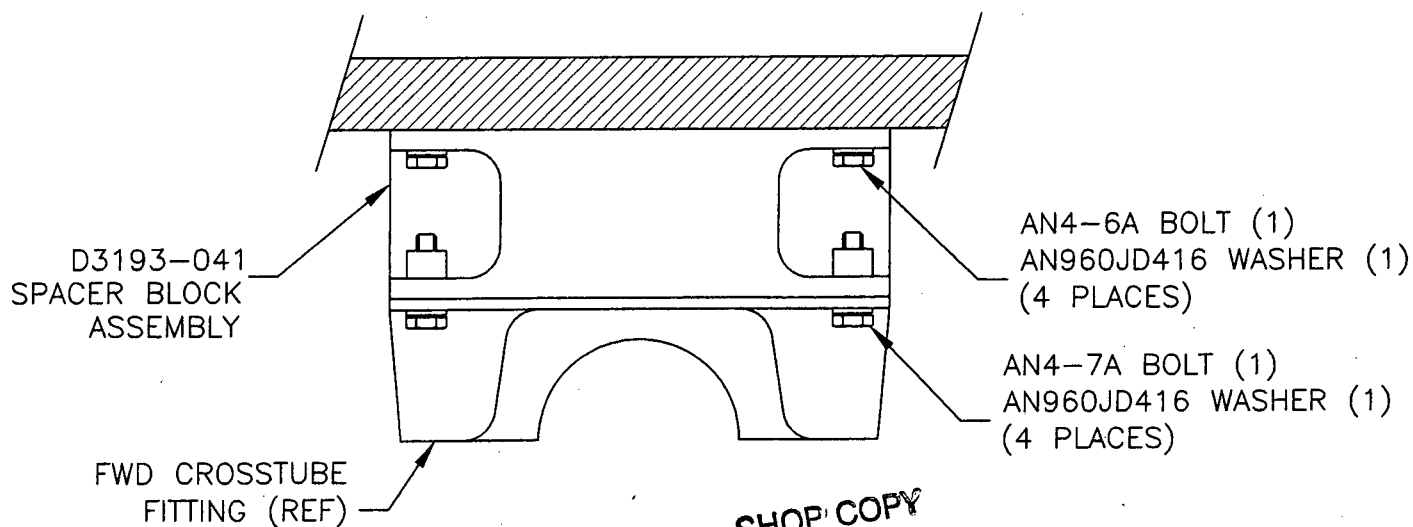
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DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9263	REV. A SHEET 1 OF 1
DATE 03.06.25		TITLE SPACER BLOCK KIT	SCALE NTS
A	03.06.25	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. A or B
REF. CANADIAN STC: SH01-5
FAA STC: SR01304NY

WHEN CONVERTING A 206 A/B AIRCRAFT FROM LOW TO HIGH GEAR BY INSTALLING D206-681-011 LANDING GEAR, THE D206-667-011 SPACER BLOCK KIT (OR EQUIVALENT) MUST BE INSTALLED BETWEEN THE FUSELAGE AND FWD CROSSTUBE FITTINGS BEFORE INSTALLING THE LANDING GEAR ON THE AIRCRAFT.



SHOP COPY
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ENGINEERING

QTY -011	Part Number	Description
X	D206-667-011	SPACER BLOCK KIT
8	AN4-6A	BOLT
8	AN4-7A	BOLT
16	AN960JD416	WASHER
2	*D3193-041	SPACER BLOCK ASSEMBLY

* OR AA P/N 206-321-005 OR BHT P/N 206-031-586-003

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WORK ORDER
NO. 24048

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 03.06.09
CERT. NO.: SH01-05
ISSUE NO.: 1/2

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 11, 2005
01:37 pm

Work Order No : 0024048
Project Name : D206-667-011
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : *D206-667-011
Description : Spacer Block Kit
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 08-11-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 24048
Description:		Part Number: D3193
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	± .010	3.436	/			
2.012	--	2.013	/			
1.200	--	1.205	/			
2.006	--	2.004	/			
.264	--	.265	/			
R.125	--	R.125				
2.435	--	2.435	/			
.281						
.500						
5.878	--	5.879	/			
4.878	--	4.879	/			
2.550	--					
2.550	--	2.549	/			
Ø .098	--	Ø .099	/			
CSK .180 X 100°	± .010	.175 X 100°	/			
Ø .266	--	.270	/			
R.50	--	R.50	/			
.260	± .010	.262	✓			
Ø .500	--	.500	/			

Measured by: SA	Audited by: ml	Prototype Approval:
Date: 05.08.23	Date: 05/08/24	Date: M/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Roberto Fuentes

From: David Shepherd [davids@dartaero.com]
Sent: Monday, September 26, 2005 1:28 PM
To: Roberto Fuentes
Subject: Re: D3193-041 rivet/ spacedoor

Hi Roberto,

Both of these changes are acceptable to me. Please make sure the relevant drawings are updated accordingly. I can sign when I am there later this week.

David

----- Original Message -----

From: Roberto Fuentes
To: David Shepherd
Sent: Thursday, September 22, 2005 11:20 AM
Subject: D3193-041 rivet/ spacedoor

Hi David,

Two issue,

1) D3193-041 bracket the ipp and dwg call for MS20426AD3-8 rivet very often crack because the only tool access to that area. They try with -7 rivet is better see picture but to get right dia of the mushroom is rivet of the left on -001, on right on the same picture is 0.02 less on dia of the mushroom. See picture call bracket 001 is -7 and 002 is -8 size. It is acceptable to change?

2) Spacedoor was a problem with lever touching the bracket, Dan and I propose to move clamp more closer of the edge of D3163-3 so is leaving 0.125" of the edge of the hole to the edge of plate. Monique open those holes to 0.285" dia. in the plate see picture. If the change make sense to you, we going to try first on the HAI spacedoor.

Thanks,
Roberto